

D212-805-011 POD MODIFICATION KIT
 (COMPATIBLE WITH D212-601-041/-042 HELI-UTILITY-POD)
 (RH INSTALLATION SHOWN, LH INSTALLATION OPPOSITE)

NOTES:

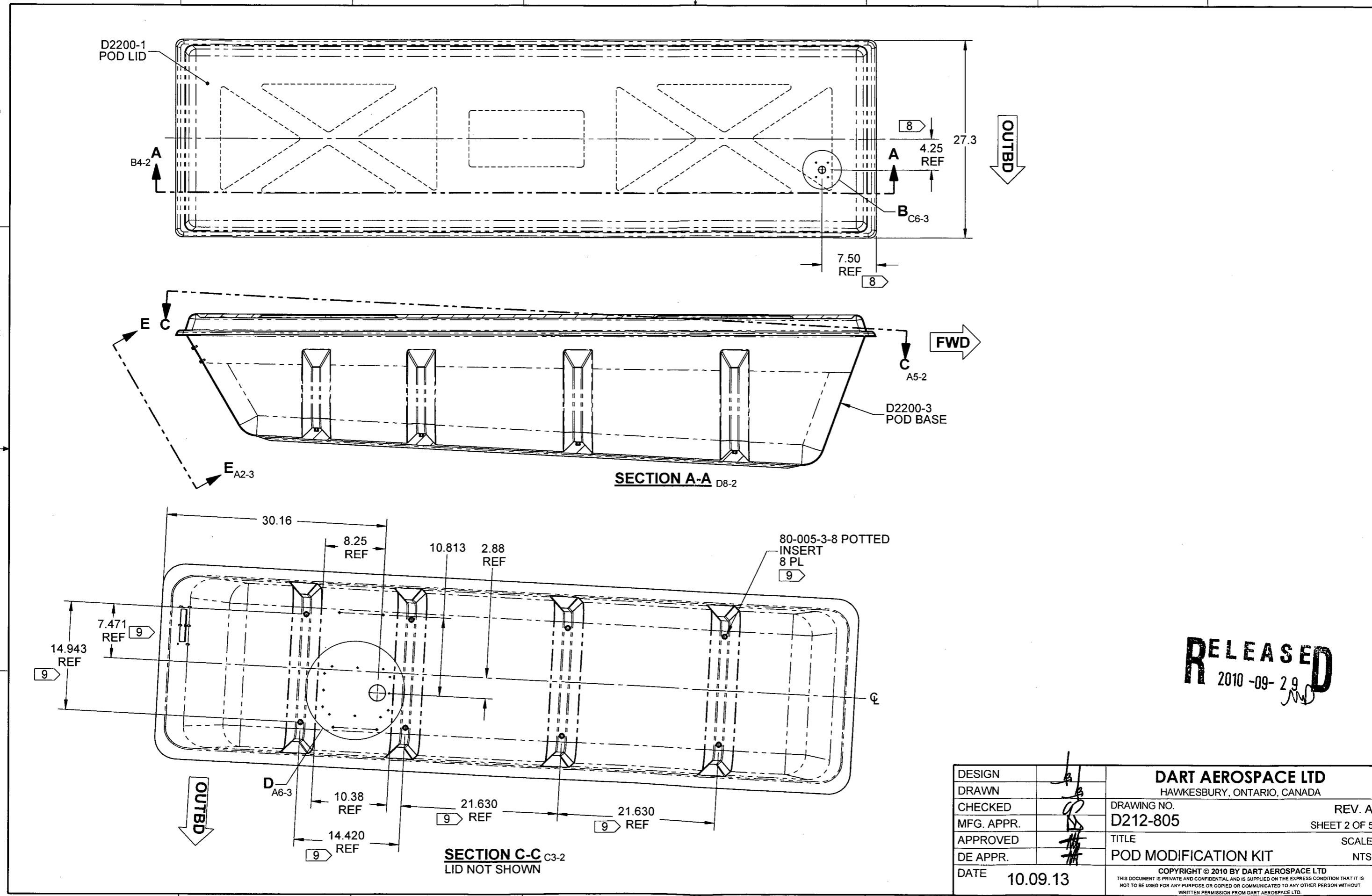
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 20 lbs APPROX
- 8) ENSURE D4175-041 WILL CLEAR D2200-1 LID FOAM CORE.
 USE DT9667 CUTOUT TEMPLATE TO FASTEN/BOND D4175-041 TO D2200-1 LID.
 REMOVE FASTENERS AND DT9667 TEMPLATE ONCE COMPLETELY CURED.
- 9) FOR INSTALLATION OF D4172-041 FRAME AND 80-005-3-8 INSERTS:
 - 9.1) LOCATE D4172-041 FRAME INSIDE POD SO THE FASTENER HOLES ARE MORE OR LESS ON THE CENTERLINE OF EACH D2200-3 POD RIBS;
 - 9.2) TRANSFER MARK AND DRILL SAME SIZE DIAMETER AS THE INSERT SHAFT DIAMETER TO A MAXIMUM OF 1.250" DEEP;
 - 9.3) CLEAN OUT FOAM CORE \varnothing 0.125" TO 0.250" AROUND HOLE BETWEEN OUTER AND INNER SKINS;
 - 9.4) FOR EACH CAVITY, FILL ONE THIRD WITH "HYSOL EA394" OR EQUIVALENT EPOXY COMPOUND;
 - 9.5) INSTALL 80-005-3-8 INSERTS BY FILLING THE CAVITY WITH "HYSOL EA394" PER QSI 006 14.6 ENSURING INSIDE OF INSERTS ARE FREE OF POTTING COMPOUND;
 - 9.6) GRIND TO A SMOOTH SURFACE AS REQUIRED AFTER EPOXY HAS COMPLETELY CURED;
 - 9.7) TOUCH UP FINISH USING DUPONT HIGBUILD PRIMER GREY #1104S OR #1144S.
- 10) TRANSFER DRILL HOLES IN POD AND D4177-1 DOUBLERS TO D3926-3 WEDGES PRIOR TO FASTENING D3926-3 TO POD.
- 11) SEAL EDGES OF ALL DRILLED HOLES AND CUTOUTS WITH CYANOACRYLATE GLUE (CRAZY GLUE)
- 12) WET INSTALL D3926-3, D4173-3/-7, D4174-1/-3, D4175-041, D4177-1 USING SIKAFLEX 241/291 ADHESIVE
- 13) IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND INSERT SHIMS AS REQUIRED BETWEEN THE POD RIBS AND D4172-041 FRAME.
 MANUFACTURE 1.00" X 1.00" SHIMS TO REQUIRED THICKNESS FROM M6061T6S OR M6061T6B ALUMINUM.

ITEM	QTY. -011	P/N	DESCRIPTION
X	D212-805-011	POD MODIFICATION KIT	
12	1	D3926-3	WEDGE
	2	D4172-041	POD MOUNTING FRAME ASSY
	3	D4173-041	POD RADALT MOUNTING PLATE ASSY
	4	D4173-3	POD RADALT DOUBLER
	5	D4173-7	RADALT SHIM
	6	D4173-9	POD RADALT SEAL
	7	D4174-1	CONNECTOR PLATE
	8	D4174-3	CONNECTOR PLATE DOUBLER
	9	D4175-041	POD GPS DOUBLER ASSY
	10	D4177-1	RADALT GUARD DOUBLER
	11	80-005-3-8	POTTED INSERT
	12	AN3-5A	BOLT
13	13	AN3-6A	BOLT
	14	AN3-12A	BOLT
	16	AN4-4A	BOLT
	17	MS21042L3	NUT
	18	NAS1149D0363J	WASHER
	19	NAS1149F0332P	WASHER
	20	NAS1149F0432P	WASHER
	21	A/R N/A	SHIM

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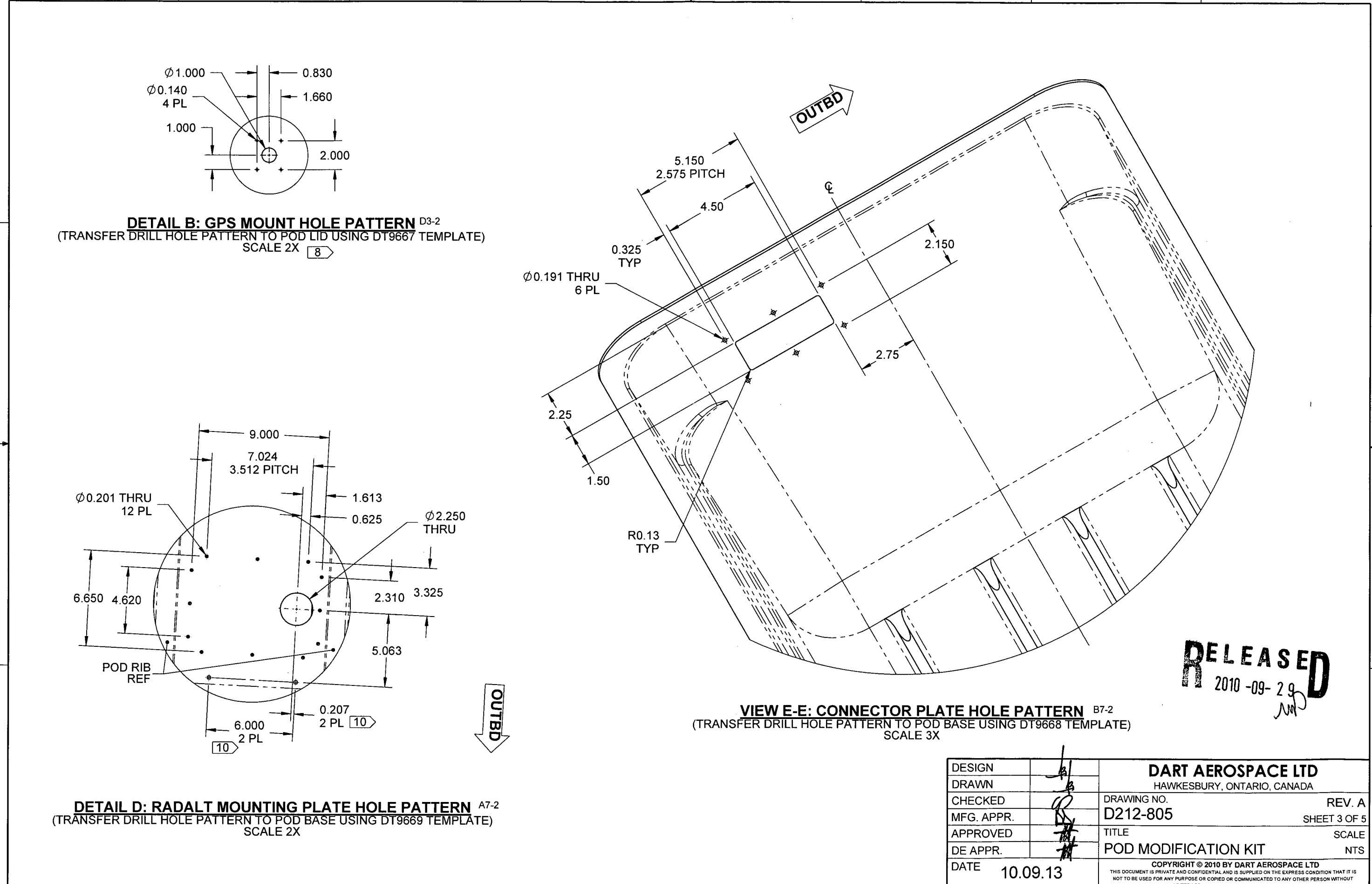
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CHECKED	<i>[Signature]</i>	DRAWING NO.	
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APPROVED	<i>[Signature]</i>	SHEET 1 OF 5	
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		POD MODIFICATION KIT	NTS

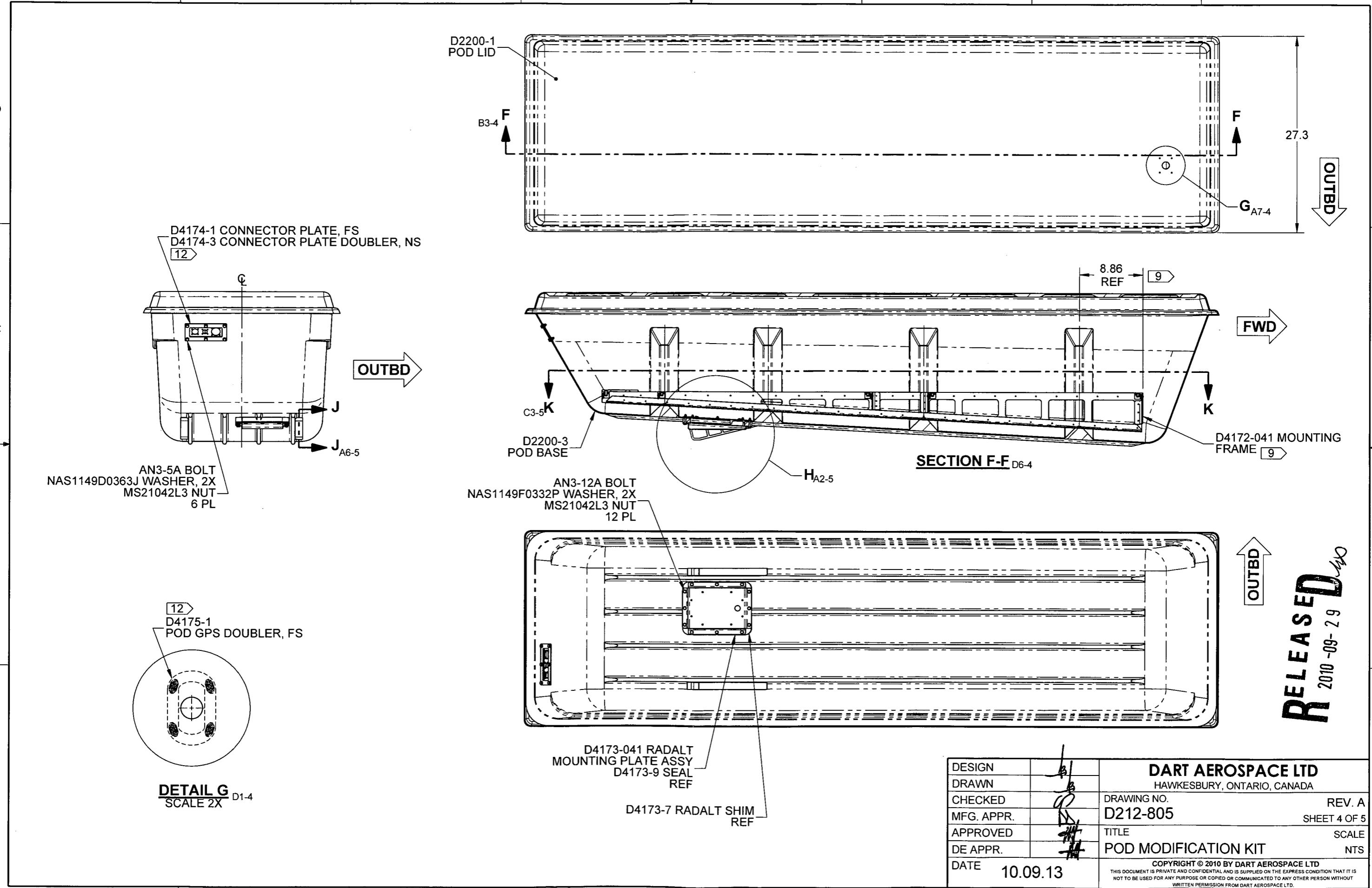
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MFG. APPR.	<i>b1</i>	D212-805
APPROVED	<i>b1</i>	REV. A
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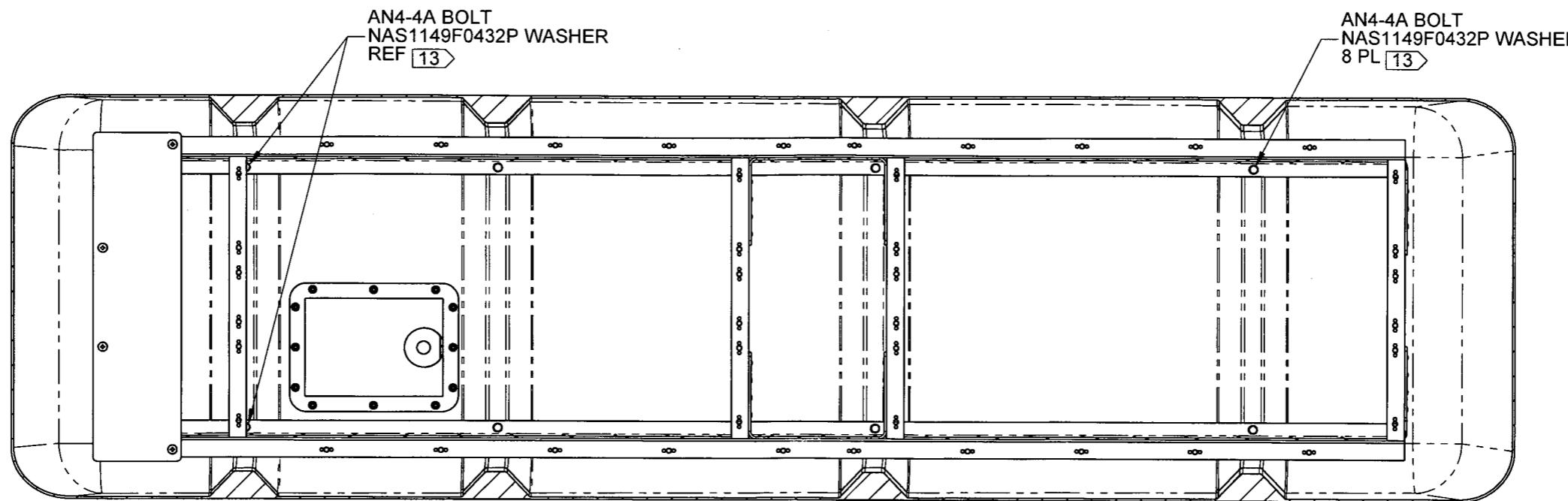
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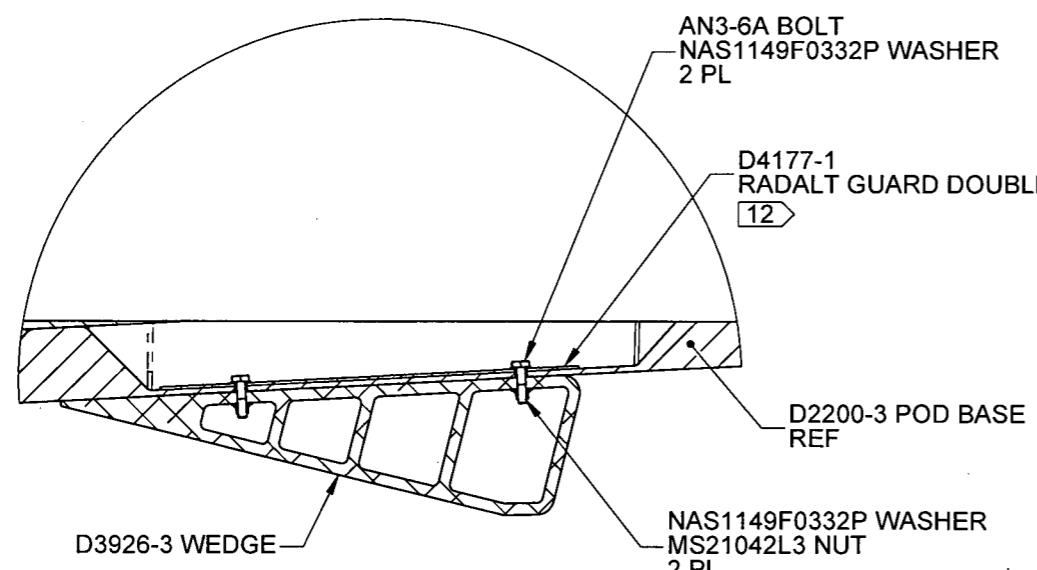


SECTION K-K: D4172-041 POD FRAME INSTALLATION C5-4

SCALE 1.5X

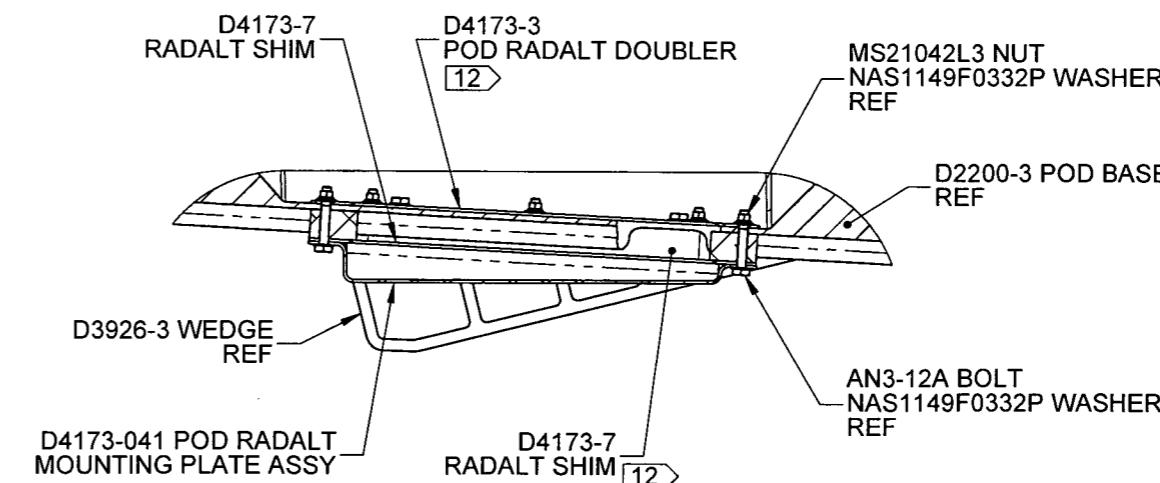
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SECTION J-J: RADALT GUARD INSTALLATION B7-4

SCALE 3X, 2 PL PER POD 10



DETAIL H: RADALT MOUNTING PLATE INSTALLATION B4-4

SCALE 3X

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